

Work Order ID 66232

February 8, 2011 8:43:20 AM



Page 1

Item ID:	D4319-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Altimeter Bracket					
Start Date:	2/08/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/22/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/02/08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4319	PA1 PA2 PA3								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 8.200"		<u>CL</u>	<u>11/2/9</u>					

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FB037 FOLIO REV: <u>PA2</u> <u>PA3</u> DWG REV: <u>PA2</u> <u>PA3</u> 2-Deburr any rough edges		<u>CL</u>	<u>11/2/9</u>					



120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

CL 11/2/9

PRELIMINARY ISSUE

Pro →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/09	110	Dim. 0,150 ^{+0,015} _{-0,000} came out at 0,148". Part acceptable RC: PROGRAM/tool OFFSET NOT VERIFIED.	 11.02.09 J.F.S.	Adjust cutter depth in prog.	J.F.S. 11/02/09 11/2/9	S 11/02/10	 11/02/09	S 11/02/10

NOTE: Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC8- Inspect parts - second check	0.00	- inspector to P23						
QC Quality Control	Memo	0.00	Dry only						
			8/11/2010 @						
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							
160 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat Powder Coating	Memo	0.00							
	START TIME: 8:00								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 8:30								

1 of all 11/02/10

1 BR 11-2-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



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Page 3

Item ID: D4319-1 Accept  Setup Start 
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Required Date: 2/22/11 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	0	11	02/11
180  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
190  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL
EFFECTIVE 11/02/11 AUTH 11
RELEASED _____ DATE _____

66062

MF
11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 66232



Parent Item: D4319-1



Parent Item Name: Altimeter Bracket

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-02-03 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No				f	9.0000		0.723263			



6061-T6 Bar 2.50 x 3.50

SA 11/2/9

Location

Loc Qty

Loc Code

MAT08

9

— 113403

9

4 R

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66232
Description: Altimeter Bracket		Part Number: A4319-1
Inspection Dwg: A4319 Rev: PA2 PA3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.45	$\pm .010$	3.45	/		Veil	SA-9
1.000	$\pm .010$	1.002	/			
1.250	$\pm .010$	1.245	/			
2.00	$\pm .030/-0.000$	2.004	/			
3.75	$\pm .010$	3.75	/			
$\phi .254$	$\pm .006/-0.001$	$\phi .258$	/			
R.13	$\pm .030$	R.125	/		R.G	
R.25	$\pm .030$	R.25	/		R.G	
.925	$\pm .010$.925	/			
.150	$\pm .020$.155	/			
.150	$\pm .015/-0.000$.152	/		Mic	SA-5
2.000	$\pm .010$	1.997	/			
.150	$\pm .015/-0.000$.148	/		Mic	ACCEPTABLE DEVIATION 11.02.09
R.188	$\pm .010$	R.187	/		R.G	
13°	$\pm .5°$	13°	/		Protractor	
$\phi .234$	$\pm .005/-0.001$	$\phi .235$	/			
.866	$\pm .010$.864	/			
.567	$\pm .010$.567	/			
1.446	$\pm .010$	1.443	/			
5.669	$\pm .010$	5.668	/			
8.00	$\pm .030$	8.000	/		Veil	

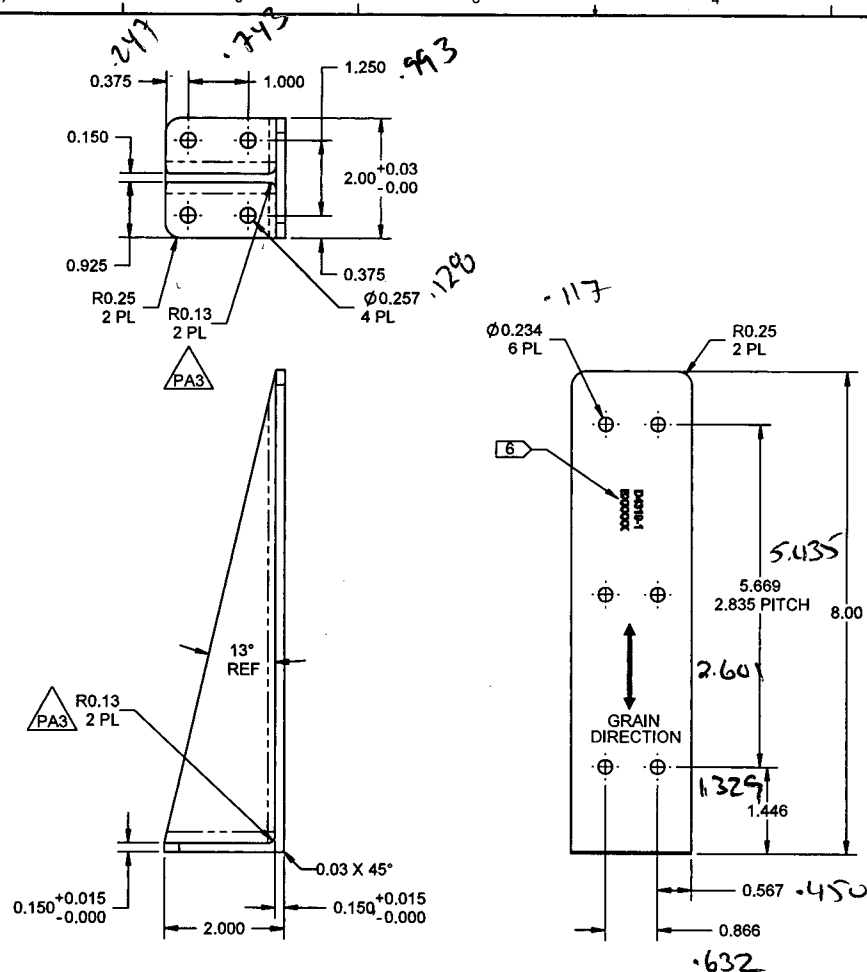
Measured by: SA
Date: 11/2/9

Audited by: S
Date: 11/2/10

Prototype Approval:
Date:

Inspector to PA3

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4319-1 ALTIMETER BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4319-1" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.40 lbs

PA3	FILLET RADS UPDATED VIEW ADDED	AJS	11.02.09
PA2	UPDATED FILLET RADS AND HOLE DIAMETERS PART WIDENED	AJS	11.02.03
PA1	PRELIMINARY	MB	11.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4319	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTIMETER BRACKET	NTS
DATE	11.02.03	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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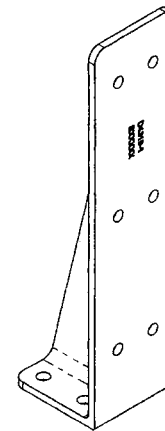
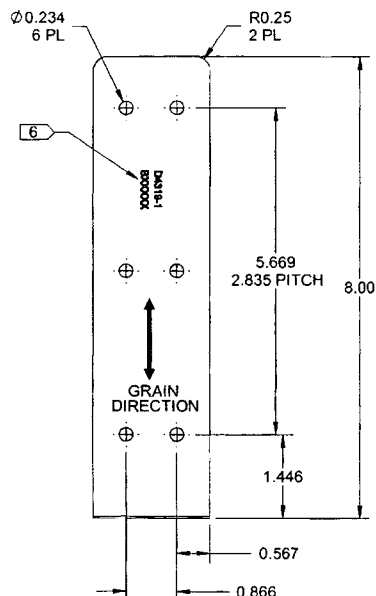
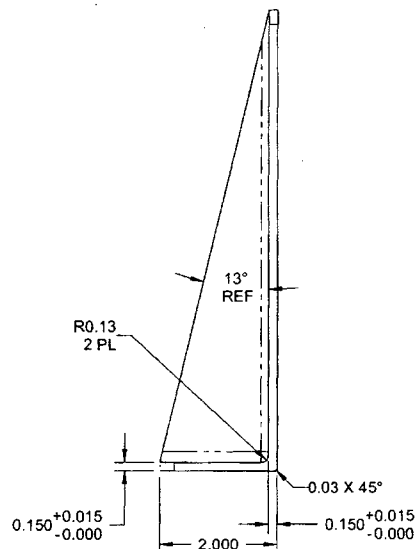
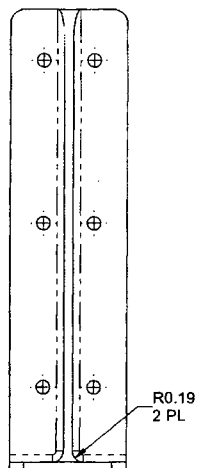
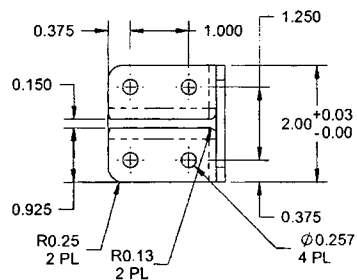
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RELEASED
2011-03-02

REV.	NEW ISSUE	DESCRIPTION	MB	11.02.03
DESIGN	MB		BY	DATE
DRAWN	AJS			
CHECKED	JS			
MFG. APPR.	JS			
APPROVED	JS			
DE APPR.	JS			
DATE	11.02.03			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4319** REV. A
SHEET 1 OF 2
TITLE **BRACKETS** SCALE NTS

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